



Dart Aerospace Ltd.
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647.9702

Job Sheet 214449



Part No: 647.9702

Job Qty: 2 pcs

DAS
21
9-89

Part Name: Upper Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/20

Job Tracking No:

Due Date: 11/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP REV:A NEW ISSUE 13-03-21 JLM VERIFIED:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	11/11/20	11/11/20	0.00	0.00	Packaging 1 - 1		DAS 58 DEC 01 2020
120	Small Fab - 2 - B4B	2 pcs	11/12/20	11/12/20	0.00	0.02	Small Fab - 1 - B4B		68-89g
							Small Fab - 2 - B4B		89g
							Small Fab - 3 - B4B		DAS DEC 01 2020
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
130	QC 5	2 pcs	11/12/20	11/12/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS 40 DEC 02 2020
							QC 5 - 9		9-89
							QC 5 - 50		
							QC 5 - 30		
140	Packaging 3-1 - Stock - B4B	2 pcs	11/12/20	11/12/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS 28 DEC 02 2020
							Packaging 3 - 6 - B4B		9-89
							Packaging 3 - 7 - B4B		



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Container No: S317460



Part: 647.9702

Job No: 214449

Serial No/Batch: S317460

Revision:

Inspector:

Exp Date:

Instructions:

Date: 12/02/20

Plex 10/23/20 9:43 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	2 pcs	11/12/20	0.00 0.00	QC 21 - SA - 21	DAS 21 DEC 03 2020
				QC 21 - SA - 70	9-89

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE

598: 5304317 exp. date: 08/22

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: ***IDENTIFY AS PER IAW MPP-120***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9711	Blade 107	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5307784
647.9711	Upper Body 047	0 pcs (0 ea)	110-Packaging 1 - Pick Kit	115251 5307355
MS21042L08	Nut 303	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	5307361
MS27039-08-19	Screw 64015	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	5316219
NAS1149FN832P	Washer (AN960-8) 203	24 Ea (12 ea)	110-Packaging 1 - Pick Kit	5309680

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9711	4	66	0
	647.9711	0	70	0
	MS21042L08	12	2,320	0
	MS27039-08-19	12	261	0
	NAS1149FN832P	24	685	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					